



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3414-3

Job Sheet 200399



Part No: D3414-3

Job Qty: 40 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 9/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time		
105	HAAS 4 Axis	40 pcs	9/25/19	1.00	20.00	HAAS - 1	52	19/11/10	
						HAAS - 2	9-89		
						HAAS - 3			
						HAAS - 4			
125	QC 8	40 pcs	9/25/19	0.00	0.00	QC 8 - 12		19/11/11	
						QC 8 - 14			
						QC 8 - 17			
						QC 8 - 20			
						QC 8 - 25			
						QC 8 - 3			
						QC 8 - 32			
						QC 8 - 33			
						QC 8 - 35			
						QC 8 - 39			
						QC 8 - 4			
						QC 8 - 44			
						QC 8 - 45			
						QC 8 - 49			
						QC 8 - 58			
						QC 8 - 8			
						QC 8 - 9			
						QC 8 - 68			
						QC 8 - 67			
						QC 8 - 1 (A)			
						QC 8 - 47			
QC 8 - 40									
QC 8 - 52									
QC 8 - 23									
QC 8 - 57									
QC 8 - 76									
140	Packaging 3-1 - Stock - B4B	40 pcs	9/25/19	0.00	0.00	Packaging 3 - 1 - B4B			



Container No: S230378



Part: D3414-3
Job No: 200399
Serial No/Batch: S230378
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/10/19



Container No: S230378



Part: D3414-3

Job No: 200399

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Instructions: Various STC's

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Date: 11/10/19

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					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	12
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	40 pcs	9/25/19	0.00	0.00	QC 21 - SA - 21	NOV 18 2019
					QC 21 - SA - 70	NOV 18 2019
					QC 21 - SA - 53	NOV 18 2019
Part Op 105 - Cut blanks: 2.50" x 0.500" x 2.250" long Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3 Dwg Rev						
Descriptions: C Folio Rev AA						
125 - (QC8- Inspect parts - second check)						
140 - (Identify as per dwg & Stock Location: 10/100)						
150 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M304B0.500X2.500	304 Bar .500 X 2.50	7.5000 ft (.1875 ea)	105-HAAS 4 Axis	5182959		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
105-HAAS 4 Axis	M304B0.500X2.500	8	19	0		

used
7.76
0.26
5.190

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug	0.510inches + 0.008 - 0.001	0.518 0.509	0.510	
2	Lug	2.070inches ± 0.030	2.100 2.040	2.068	
3	Lug	1.990inches ± 0.030	2.020 1.960	1.99	
4	Lug	1.300inches ± 0.030	1.330 1.270	1.30	
5	Lug	1.120inches ± 0.030	1.150 1.090	1.116	
6	Lug	0.380inches ± 0.030	0.410 0.350	0.383	
7	Lug	0.060inches ± 0.010	0.070 0.050	0.062	

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DAS
52
9-29

19/11/10



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐
Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (Q51042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong
☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance
☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing
☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish
☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread
☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐	

Other/Details: _____